

Work Order ID 146985

Tuesday, May 24, 2016 10:40:13 AM

146985

Page 1

Item ID: D3531-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Top Mounted Gps Bracket
 Start Date: 5/24/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 6/10/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: **MAY 26 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3531	B

100	Small Fab	0.00							
100									
Small Fab	Memo	0.48							
Small Fab	Transfer drill holes, Dimples sink and assemble as per dwg D3531								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.06							
Quality Control									

120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
120									
Powdercoat	Memo	0.39							
Powder Coating	START TIME: <u>10:15</u> FINISH TIME: <u>10:45</u> OVEN TEMPERATURE: <u>300</u>								

3X **16/07/11** **DAS 36 9-89** **P/O**

(3) **JUL 11 2016** **DAS 38 9-89**

3 **16-07-15** **233**

DQA:

Date: 16.08.09



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/07/19

Work Order update only ☐

Work Order: <u>146985</u> Part No. <u>D3531-041</u> NCR No. <u>16-5922</u>		DISPOSITION Rework ☒ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>16-07-15</u>		Step #: <u>100</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				PD 16-07-15 Completed By DAS 16/07/11 36 9-89 Lead hand / Supervisor Approval Verification DAS 30 9-89 JUL 11 2016 QC / QA Coordinator Approval PD 16-07-15	
One D3531-1 and D3531-3 is scrap. During the process we had to remove a rivet and enlarge a hole. hole was enlarged during this process				SCRAP and Destroy					
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Set-up ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Misabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☒ Misaligned/off center ☐ Turning Sequence ☐					
OTHER :									

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Top Mounted Gps Bracket

Start Date: 5/24/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.03

Quality Control

3

140

Identify as per dwg & Stock Location: S1503

0.00

140

Packaging

Memo

0.03

Packaging

3 ^{DAS}
6
9-89JUL 15 2016

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.30

Quality Control

^{DAS}
21
9-89JUL 18 2016^{DAS}
21
9-89JUL 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Picklist Print

Tuesday, May 24, 2016 10:40:12 AM

Page 1

Work Order ID: 146985

146985

Parent Item: D3531-041

D3531-041

Parent Item Name: Top Mounted Gps Bracket

Start Date: 5/24/2016

Required Date: 6/10/2016

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A New Issue 07-09-24 EC verified DD
12.10.24 PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3531-1		Manufactured	No			100	Each	2.0000	1	3			
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D3531-1

Bracket

Location

Loc Qty

Loc Code

GA

2

142152

2

D3531-3		Manufactured	No			100	Each	1.0000	1	3			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3531-3

Bracket Front Plate

Location

Loc Qty

Loc Code

GA

1

119562

1

MS20426AD4-4		Purchased	No			100	Each	4,475.000	2	6			
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MS20426AD4-4

Rivet

Location

Loc Qty

Loc Code

GA

2022

125445

2022

ST312

2453

m132536

2453

**

**

**

16/07/11
B146982 (1x)
DAS 36 9-89

16/07/11
B146983 (2x)
DAS 36 9-89

16/07/11
DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
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D3531-041

Parent Item Name: Top Mounted Gps Bracket

Start Date: 5/24/2016

Required Date: 6/10/2016

Start Qty: 3.00

Required Qty: 3.00

MS20470AD4-4

Purchased

No

100

Each

2,067.000

10

30

MS20470AD4-4

Rivet, Universal Head

16/07/11 DAS 36 +89

Location

Loc Qty

Loc Code

GA

1599

M133922

54

M134294

101

M134574

1444

ST310

468

M132803

468

M134848
(30x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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